

# Work Order ID 79773

**\*79773\***

February-03-12 8:15:41 AM

Page 1

Item ID: D412-698-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cabin Door Roller, LH  
 Start Date: 03/02/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 17/02/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 12/02/03 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr     | Revision Nbr |
|--------------|--------------|
| IIN D412-698 | Rev E        |

|                  |  |      |  |  |  |  |  |  |  |
|------------------|--|------|--|--|--|--|--|--|--|
| 100              | DOCUMENT CONTROL   | 0.00 |  |  |  |  |  |  |  |
| <b>*100*</b>     |  |      |  |  |  |  |  |  |  |
| DC               | Memo   | 0.00 |  |  |  |  |  |  |  |
| Document Control | Photocopy bluefile and create labels per PPP D412-698-011 CHG003 |      |  |  |  |  |  |  |  |

*Handwritten:* 23 Sizbe/26 for m.c.j 12-6-5 (2)

|              |          |      |  |  |  |  |  |  |  |
|--------------|----------|------|--|--|--|--|--|--|--|
| 110          | Pick Kit | 0.00 |  |  |  |  |  |  |  |
| <b>*110*</b> |          |      |  |  |  |  |  |  |  |
| Packaging    | Memo     | 0.00 |  |  |  |  |  |  |  |
| Packaging    |          |      |  |  |  |  |  |  |  |

*Handwritten:* 2 12/06/12 JB

|                 |   |      |  |  |  |  |  |  |  |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120             | QC4- 100% Inspect kits for completeness | 0.00 |  |  |  |  |  |  |  |
| <b>*120*</b>    |   |      |  |  |  |  |  |  |  |
| QC              | Memo                                    | 0.00 |  |  |  |  |  |  |  |
| Quality Control |   |      |  |  |  |  |  |  |  |

*Handwritten:* Sizbe/26 (43)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 79773****\*79773\***

Page 2

February-03-12 8:15:41 AM

Item ID: D412-698-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Cabin Door Roller, LH

Stop **\*NS2\***

Start Date: 03/02/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-011

Location:

Rev B

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

2x

50  
12-6-26

12/6/26

ME

12-06-26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

February-03-12 8:15:44 AM

Page 1

Work Order ID: 79773

\*79773\*

Parent Item: D412-698-011

\*D412-698-011\*

Parent Item Name: Cabin Door Roller, LH

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from  
Step 1,3KJ/DS  
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

S  
72  
D3121-141\*  
Bracket Assembly

|           |  |              |    |  |  |     |      |        |   |   |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3121-141 |  | Manufactured | No |  |  | 100 | Each | 9.0000 | 3 | 6 |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

\*\*  
83457 JB

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST235A   | 9       |          |
| 75030    | 9       |          |

S  
72  
D3121-143\*  
Bracket Assembly

|           |  |              |    |  |  |     |      |        |   |   |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3121-143 |  | Manufactured | No |  |  | 110 | Each | 6.0000 | 1 | 2 |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

\*\*  
80098 JB

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST235A   | 6       |          |
| 68265    | 2       |          |
| 75031    | 4       |          |

S  
72  
D3183-043\*  
Bracket Assembly

|           |  |              |    |  |  |     |      |        |   |   |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3183-043 |  | Manufactured | No |  |  | 110 | Each | 5.0000 | 1 | 2 |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

\*\*  
82688 JB

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST235    | 5       |          |
| 70299    | 1       |          |
| 75033    | 4       |          |

S  
72  
D3137-043\*  
Bracket Assembly

|           |  |              |    |  |  |     |      |        |   |   |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3137-043 |  | Manufactured | No |  |  | 110 | Each | 0.0000 | 1 | 2 |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

\*\*  
2x 83467 JB 12/06/12

1708

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

February-03-12 8:15:44 AM

Page 2

Work Order ID: 79773

**\*79773\***

Parent Item: D412-698-011

**\*D412-698-011\***

Parent Item Name: Cabin Door Roller, LH

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

39.0000

9 18

**\*D3199-1\***

Bracket

\*\*

83860 JB

Location

Loc Qty

Loc Code

ST236A

39

61484

2

73363

4

75035

5

76212

28

D3202-1

Manufactured No

110

Each

23.0000

1 2 ✓

**\*D3202-1\***

φ Cover

\*\*

82663 JB

12/06/12

Location

Loc Qty

Loc Code

ST241A

23

70294

23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Part Number  | Description                |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|----------------------------|
| X           |             |             |             |             |             | D412-698-011 | CABIN DOOR ROLLER KIT, LH  |
|             | X           |             |             |             |             | D412-698-012 | CABIN DOOR ROLLER KIT, RH  |
|             |             | X           |             |             |             | D412-698-013 | DOOR HANDLE KIT            |
|             |             |             | X           |             |             | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
|             |             |             |             | X           |             | D412-698-019 | BEARING OVERHAUL KIT       |
|             |             |             |             |             | X           | D412-698-021 | REPLACEMENT SHIM KIT       |
| 3           | 3           |             |             |             |             | D3121-141    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3121-143    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3121-144    | BRACKET ASSEMBLY           |
| 1           | 1           |             |             |             |             | D3137-043    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3183-043    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3183-044    | BRACKET ASSEMBLY           |
| 9           | 9           |             | 9           |             |             | D3199-1      | BRACKET                    |
| 1           | 1           |             | 1           |             |             | D3202-1      | COVER                      |
|             |             | 4           |             |             |             | D3203-1      | HANDLE                     |
|             |             | 1           |             |             |             | D3220-041    | DOUBLER                    |
|             |             | 1           |             |             |             | D3220-042    | DOUBLER                    |
|             |             | 2           |             |             |             | D3220-3      | DOUBLER                    |
|             |             |             |             | 7           |             | D3121-21     | BOLT                       |
|             |             |             |             | 5           |             | D3121-241    | BEARING ASSEMBLY           |
|             |             |             |             | 1           |             | D3137-3      | GUIDE                      |
|             |             |             |             | 1           |             | D3137-5      | WASHER                     |
|             |             |             |             | 2           |             | D3183-045    | BEARING ASSEMBLY           |
|             |             |             |             |             | 3           | D3238-1      | SHIM                       |
|             |             |             |             |             | 1           | D3238-3      | SHIM                       |
|             |             |             |             |             | 2           | D3238-5      | SHIM                       |
|             |             |             |             |             | 6           | D3238-11     | SHIM                       |
|             |             |             |             |             | 2           | D3238-13     | SHIM                       |
|             |             |             |             |             | 4           | D3238-15     | SHIM                       |
|             |             | 8           |             |             |             | AN960JD416L  | WASHER                     |
|             |             | 8           |             |             |             | MS21042L4    | NUT (OR MS21042-4)         |
|             |             | 16          |             |             |             | MS24694-S98  | SCREW                      |
|             |             |             |             | 1           |             | MS24694-S101 | SCREW                      |